

AMENDMENTS TO THE CLAIMS:

The following listing of claims replaces all prior listings, and all prior versions, of claims in the application.

LISTING OF CLAIMS:

1.-4. (Cancelled).

5. (Previously presented) A hollow frame member according to claim 19, wherein said corner portion is positioned at an extension line of a center in said thickness of said third plate.

6. (Previously presented) A hollow frame member according to claim 19, wherein said corner portion is positioned apart from a center line of thickness of said third plate.

7. (Cancelled).

8. (Previously presented) A hollow frame member according to claim 15, wherein said second recessed portion is provided at a connection portion of said third plate and said one end of said second plate.

9. (Cancelled).

10. (Previously presented) A hollow frame member according to claim 16, wherein said second corner portion is positioned at an extension line of a center in said thickness of said third plate.

11. (Previously presented) A hollow frame member according to claim 16, wherein said second corner portion is positioned apart from a center line of said thickness of said third plate.

12.-14. (Cancelled).

15. (Currently amended) A hollow frame member according to claim 18, wherein:

at said one end of said second plate, a second recessed portion is provided in said second plate along to said one end of said second plate,

said second recessed portion opens directed toward an outer side in a thickness direction of said hollow frame member and said one end direction of said hollow frame member, and is defined by a further substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member and by a further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned within said ~~in a range, in the horizontal direction, of said~~ thickness of said third plate in said horizontal direction,

said second recessed portion is a portion capable of having said ~~a~~ friction stir welding carried out therein by inserting a further rotary tool therein, and

in said friction stir welding, a center of said further rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of

said further substantially vertical surface facing outward laterally to said thickness direction of said hollow frame member.

16. (Currently amended) A hollow frame member adapted to be used in a friction stir welding which is carried out by rotary tools, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned within a range, ~~in said horizontal direction,~~ of a thickness of said third plate in said horizontal direction,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool, of said rotary tools, therein, and

in said friction stir welding, a center of said rotary tool is inserted into

said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said recessed portion is provided at a connection portion of said third plate and said one end of said first plate, and

wherein a first corner portion from said first plate to said recessed portion is positioned in a range of an extension line of said third plate,

and wherein:

at a side of an outer face of said one end of said second plate, a second recessed portion is provided in said second plate along to said one end of said second plate,

said second recessed portion opens directed to one outer side in a thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a further substantially vertical surface facing outwardly in said horizontal direction, laterally to said thickness direction of said hollow frame member, and by a further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said further substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned within said ~~in a range, in the horizontal direction,~~ of thickness of said third plate in said horizontal direction,

said second recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a further rotary tool, of said rotary tools, therein, and

in said friction stir welding, a center of said further rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of

said further substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said second recessed portion is provided at a connection portion of said third plate and said one end of said second plate,

wherein a second corner portion from said second plate to said second recessed portion is positioned within said range of said extension line of said third plate,

wherein said third plate sustains a vertical force produced by said rotary tool during said friction stir welding, ~~and~~

wherein a first raised portion is protruded from said first plate outside toward a side of said rotary tool when said friction stir welding of said first plate is being performed, and is plasticized by said rotary tool during said friction stir welding of said first plate,

wherein a second raised portion is protruded from said second plate toward a side of said further rotary tool when said friction stir welding of said second plate is being performed, and is plasticized by said further rotary tool during said friction stir welding of said second plate, and

wherein said third plate sustains a vertical force produced by said further rotary tool during said friction stir welding of said second plate.

17. (Currently amended) A member adapted to be used in a friction stir welding which is carried out by rotary tools, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and

substantially perpendicular to said second plate and extending in a thickness direction of the member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

in one end of said member, in one outer face in a thickness direction of said member and another outer face in said thickness direction of said member, recessed portions are provided respectively,

said recessed portion of said one outer face opens directed to one outer side in said thickness direction of said member and one end direction of said member, and is defined by one substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said member, and by one substantially horizontal surface facing outwardly in said thickness direction of said member,

said recessed portion of said one outer face is provided at a connection portion of said third plate and said one end of said first plate,

a corner portion from said first plate to said recessed portion is positioned in a range of an extension line of said third plate,

said recessed portion of said another outer face opens directed to another outer side in said thickness direction of said member and one end direction of said member, and is defined by another substantially vertical surface facing outwardly in said horizontal direction, laterally to said thickness direction of said member, and by another substantially horizontal surface facing outwardly in said thickness direction of said member,

said recessed portion of said another outer face is provided at a connection portion of said third plate and said one end of said second plate,

a corner portion from said second plate to said recessed portion is positioned in said range of said extension line of said third plate,

said one substantially horizontal surface facing outwardly in said thickness direction of said member is positioned within ~~in a range, in said horizontal direction,~~ of thickness of said third plate in said horizontal direction,

said another substantially horizontal surface facing outwardly in said thickness direction of said member is positioned within ~~in said range, in said horizontal direction,~~ of said thickness of said third plate in said horizontal direction,

said respective recessed portions are portions capable of having said friction stir welding carried out therein by inserting a rotary tool, of said rotary tools, therein,

in said friction stir welding, a center of said rotary tool is inserted into said member and is substantially coincided with an extension line of said one substantially vertical surface facing outwardly laterally to said thickness direction of said member, and

in said friction stir welding, ~~a~~ said center of ~~a~~ said rotary tool, of said rotary tools, is inserted into said member and is substantially coincided with an extension line of said another substantially vertical surface facing outwardly laterally to said thickness direction of said member,

wherein said third plate sustains a vertical force produced by said rotary tool during ~~said~~ friction stir welding of said first plate,

wherein a first raised portion is protruded from said first plate outside toward a side of said rotary tool when said friction stir welding of said first plate is being performed, and is plasticized by said rotary tool during said friction stir welding of said first plate, and

wherein a second raised portion is protruded from said second plate outside toward said side of said rotary tool when said friction stir welding of said second plate is performed, and is plasticized by said rotary tool during said friction stir welding of said second plate, and
wherein said third plate sustains a vertical force produced by said rotary tool during friction stir welding of said second plate.

18. (Currently amended) A hollow frame member adapted to be used in a friction stir welding which is carried out by rotary tools, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member, and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned ~~within~~in a range, in the horizontal direction, of thickness of said third plate in said horizontal direction,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool, of said rotary tools therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said third plate sustains a vertical force produced by said rotary tool during said friction stir welding of said first plate, and

wherein a first raised portion is protruded from said first plate outside toward a side of said rotary tool when said friction stir welding of said first plate is being performed, and is plasticized by said rotary tool during said friction stir welding of said first plate,

wherein a second raised portion is protruded from said second plate toward a side of a further rotary tool when said friction stir welding of said second plate is being performed, and is plasticized by said further rotary tool during said friction stir welding of said second plate, and

wherein said third plate sustains a vertical force produced by said further rotary tool during said friction stir welding of said second plate.

19. (Currently amended) A hollow frame member adapted to be used in a friction stir welding which is carried out by rotary tools, comprising:

a first plate, a second plate which is substantially in parallel to said first plate, a third plate for connecting one end of said first plate and one end of said second plate, said third plate being substantially perpendicular to said first plate and substantially perpendicular to said second plate and extending in a thickness direction of the hollow frame member, and a plurality of ribs arranged in a form of trusses to connect said first plate and said second plate,

at a side of an outer face of said one end of said first plate, a recessed portion is provided in said first plate along to said one end of said first plate,

said recessed portion opens directed to one outer side in said thickness direction of said hollow frame member and one end direction of said hollow frame member, and is defined by a substantially vertical surface facing outwardly in a horizontal direction, laterally to said thickness direction of said hollow frame member, and by a substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member,

said substantially horizontal surface facing outwardly in said thickness direction of said hollow frame member is positioned within a range, ~~in the horizontal direction,~~ of thickness of said third plate in the horizontal direction,

said recessed portion is a portion capable of having said friction stir welding carried out therein by inserting a rotary tool, of said rotary tools, therein, and

in said friction stir welding, a center of said rotary tool is inserted into said hollow frame member and is substantially coincided with an extension line of said substantially vertical surface facing outwardly laterally to said thickness direction of said hollow frame member,

wherein said recessed portion is provided at a connection portion of said third plate and said one end of said first plate, and

wherein a corner portion from said first plate to said recessed portion is positioned in a range of an extension line ~~in said thickness~~ of said third plate, said third plate sustaining a vertical force produced by said rotary tool during said friction stir welding of said first plate, and

wherein a first raised portion is protruded from said first plate outside toward a side of said rotary tool and is plasticized by said rotary tool during said friction stir welding, wherein a second raised portion is protruded from said second plate toward a side of a further rotary tool and when said friction stir welding is being performed and is plasticized by said further rotary tool during said friction stir welding, and
wherein said third plate sustains a vertical force produced by said further rotary tool during said friction stir welding.

20. (Currently amended) A hollow frame member according to claim 16, wherein said substantially horizontal surface and said further substantially horizontal surface are positioned adjacent said third plate in ~~said the range, in the horizontal direction,~~ of thickness of said third plate in said horizontal direction.

21. (Currently amended) A member according to claim 17, wherein said one substantially horizontal surface and said another substantially horizontal surface are positioned adjacent ~~said the~~ third plate in ~~said the range, in the horizontal direction,~~ of thickness of said third plate in said horizontal direction.

22. (Currently amended) A hollow frame member according to claim 18, wherein said substantially horizontal surface is positioned adjacent said third plate in

said~~the range, in the horizontal direction,~~ of thickness of said third plate in said
horizontal direction.

23. (Currently amended) A hollow frame member according to claim 19,
wherein said substantially horizontal surface is positioned adjacent said third plate in
said~~the range, in the horizontal direction,~~ of thickness of said third plate in said
horizontal direction.

24. (Currently amended) A member according to claim 15, wherein said one
substantially horizontal surface and said another substantially horizontal surface are
positioned adjacent said~~the~~ third plate in said~~the range, in the horizontal direction,~~ of
thickness of said third plate in said horizontal direction.